

Date: Wednesday, 12/7/2005 8:26:03 AM
User: Kim Johnston

Process Sheet

| | |
|--|---|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : CROSSBOLT SPACER |
| Job Number : 25138 | |
| Estimate Number : 10993 | |
| P.O. Number : N/A | Part Number : D2579 |
| This Issue : 12/7/2005 S.O. No. : N/A | Drawing Number : D2579 REV D |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : N/A Type : MACHINED PARTS | Drawing Revision : D |
| Previous Run : N/A | Material : N/A |
| Written By : See comment below | Due Date : 1/13/2006 Qty: 500 Um: Each |
| Checked & Approved By : See comment below | |
| Comment : Est E 02.06.17 Now turned on Cobra NG | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---|-----------------------|--|
| 1.0 | M6061T6T0500W058 | 6061-T6 Tube .500 x.058W |
| | | |
| Comment: Qty.: 3.1354 f(s)/Unit Total: 1567.7025 f(s) 6061-T6 Tube .500 x.058W Material: 6061-T6 (WW-T-700/6) or 5052-H32 (WW-T-700/4) 0.500 Dia x 0.058 Wall Batch 128-120 128-120 " 129.15 M18740=57F 1/2 M18149=12F M17267=82F 1/2 M19405=30' Jul 05/12/12 500 | | |
| 2.0 | HARDINGE | HARDINGE CNC LATHE SMALL |
| | | |
| Comment: HARDINGE CNC LATHE SMALL Machine as per Folio FA245 Jul 05/12/12 500 | | |
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
| | | |
| Comment: INSPECT PARTS AS THEY COME OFF MACHINE Jul 05/12/12 500 | | |
| 4.0 | QC8 | SECOND CHECK |
| | | |
| Comment: SECOND CHECK BG 06.01.07 500 | | |
| 5.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
| | | |
| Comment: PACKAGING RESOURCE #1 Identify and Stock Location: _____ Lu 06/01/09 500 | | |

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: 12 Date: 24/01/10
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Wednesday, 12/7/2005 8:26:03 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CROSSBOLT SPACER

Job Number: 25138

Part Number: D2579

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

545 06/01/11

506

DP

06/01/10

50

Job Completion



| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

| | | |
|--|---------------------|--------------------|
| DART AEROSPACE LTD | Work Order: | 25138 |
| Description: Cross Bolt Spacer | Part Number: | D2579 |
| Inspection Dwg: D2579 Rev: D | | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

First Article

Prototype

[illegible]

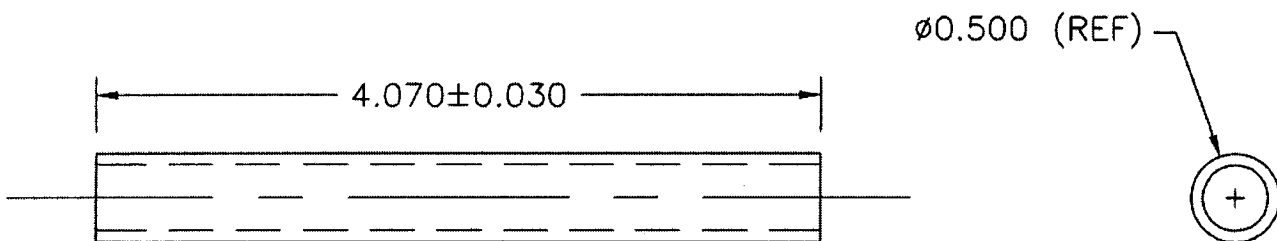
| | | | |
|-------------------------|-----------------------|---------------------|-------------|
| Measured by: <i>gml</i> | Audited by: <i>EP</i> | Prototype Approval: | N/A |
| Date: <i>05/12/12</i> | Date: <i>05/12/12</i> | Date: | <i>N/A.</i> |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------|------------|----------|
| A | 03.11.27 | New Issue | KJ/RF | |



| | | | |
|--------------------------|----------------|---|------------------------|
| DESIGN DA | DRAWN BY RF | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED DA | APPROVED LE | DRAWING NO. D2579 | REV. D SHEET 1 OF 1 |
| DATE 99.05.19 | | TITLE CROSS BOLT SPACER | SCALE 1:1 |
| A | 96.09.16 | NEW ISSUE | |
| B | 96.12.05 | 0.065 WALL WAS 0.035 WALL | |
| C | 97.02.21 | 0.058 WALL WAS 0.065 WALL | |
| D | 99.05.19 | 4.070 LENGTH WAS 4.100 (TSR A1095) | |

RELEASED
99.05.20 DS



ENGINEERING
APPROVED COPY
NOMENCLATURE
OFFICE

ORDER
25138

MATERIAL: 6061-T6 (WW-T-700/6) OR 5052-H32 (WW-T-700/4)
0.500 DIA x 0.058 WALL
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED